

JAN 16

Work Order ID 154967***154967***

Page 1

Wednesday, January 04, 2017 11:33:56 AM

Item ID: D3808-1

Revision ID:

Item Name: Seat Rail

Start Date: 1/6/2017

Start Qty: 2.00

Required Date: 1/11/2017

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date: JAN 04 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3808

Rev A

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 16.125 " long

0.00

DAS
33
9-89

17/01/09

110

0.07

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA771 Rev: AA & Dwg D3808 Rev: A 2-Tap holes for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 4-Deburr per dwg D3808

0.25

DAS
33
9-89

17/01/12

DAS
44
9-89

17-01-11

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

DAS
33
9-89

17/01/12

DAS
44
9-89

17-01-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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154967

Wednesday, January 04, 2017 11:33:56 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/6/2017 **Start Qty:** 2.00 ***2***

Required Date: 1/11/2017 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

130

QC

Memo

0.01

Quality Control

DAS
14
9-89

17/01/20

0.00

140

HandFinish

Memo

0.03

Hand Finishing

8X

2017/01/25
BEB

0.00

141

OC

Memo

0.00

Quality Control

DAS
38
9-89

IAN 26 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
2AO PT 00-0								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Work Order ID 154967

Wednesday, January 04, 2017 11:33:56 AM

154967

Page 3

Item ID: D3808-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Rail

Start Date: 1/6/2017 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 1/11/2017 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>St 258</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.03							
Quality Control									

8 **DAS**
21
9-88

JAN 30 2017

17/01/30 *AF*
*me**17-1-30*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, January 04, 2017 11:33:56 AM

Page 1

Work Order ID: 154967

154967

Parent Item: D3808-1

D3808-1

Parent Item Name: Seat Rail

Start Date: 1/6/2017

Required Date: 1/11/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	12.6670	1.35	2.842105			

M6061T6B2 000X01 250

**

DAS
33
9-89

6061-T6 Bar 2.00 x 1.25

17/01/09

Location

Loc Qty

Loc Code

MAT

0.667

m134191

0.667

MAT003

12

m136327

12

10, 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER : _____																																																															

DART AEROSPACE LTD		Work Order:	154967
Description: Seat Rail		Part Number:	D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	/		Tape	FK-05
7.30	+/-0.030	7.305	/		CNC-02	Vern.
0.550	+/-0.010	.550	/		Vern	FK-05
0.85	+/-0.030	.85	/		"	"
0.780	+/-0.010	.780	/		"	"
Ø0.391	+0.006/-0.001	.390	/		"	"
3/8-16 UNC	N/A	3/8-16 UNC	/		—	
Ø0.323	+0.006/-0.001	.323	/		Vern	FK-04
Ø0.695 x 100°	+/-0.010 x 0.5°	.695 x 100°	/		"	"
Ø0.172	+0.005/-0.001	.173	/		"	"
8-32 UNC	N/A	8-32 UNC	/		—	
0.800 x 0.667 deep	+/-0.010	.800 x .670	/		Vern	FK-04
2.00	+/-0.030	2.005	/		"	"
R0.26	+/-0.030	.26	/		R-G	
6.13	+/-0.030	6.125	/		Vern	CNC-02
5.13	+/-0.030	5.125	/		"	"
0.16	+/-0.030	.158	/		"	FK-04
1.75	+/-0.030	1.75	/		"	"
15.88	+/-0.030	15.875	/		Tape	FK-05
0.965	+/-0.010	.963	/		Vern	FK-04
0.375	+/-0.010	.372	/		"	"
1.10	+/-0.030	1.10	/		"	"
0.140	+/-0.010	.140	/		"	"
0.373	+/-0.010	.373	/		"	"
0.030 x 45°	+/-0.010 x 0.5°	.030 x 45°	/		"	"
R0.06	+/-0.030	.06	/		R-G	
0.347	+/-0.010	.346	/		Vern	FK-04
0.270	+0.030/-0.000	.270	/		"	"
Ø0.720	+0.005/-0.010	.722	/		"	"
R0.063	+/-0.010	.063	/		R-G	
0.320	+0.020/-0.000	.322	/		Vern	FK-04
R0.015	+/-0.010	.015	/		R-G	
0.655	+0.015/-0.010	.653	/		Vern	FK-04
0.350	+/-0.010	.351	/		"	"
0.030 x 45°	+/-0.010 x 0.5°	.030 x 45°	/		"	"
0.667	+/-0.010	.671	/		"	"

DART AEROSPACE LTD		Work Order:	154967
Description: Seat Rail		Part Number:	D3808-1
Inspection Dwg: D3808 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

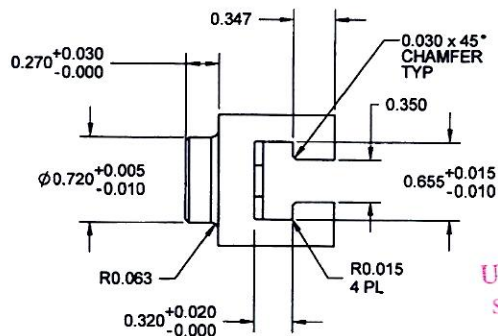
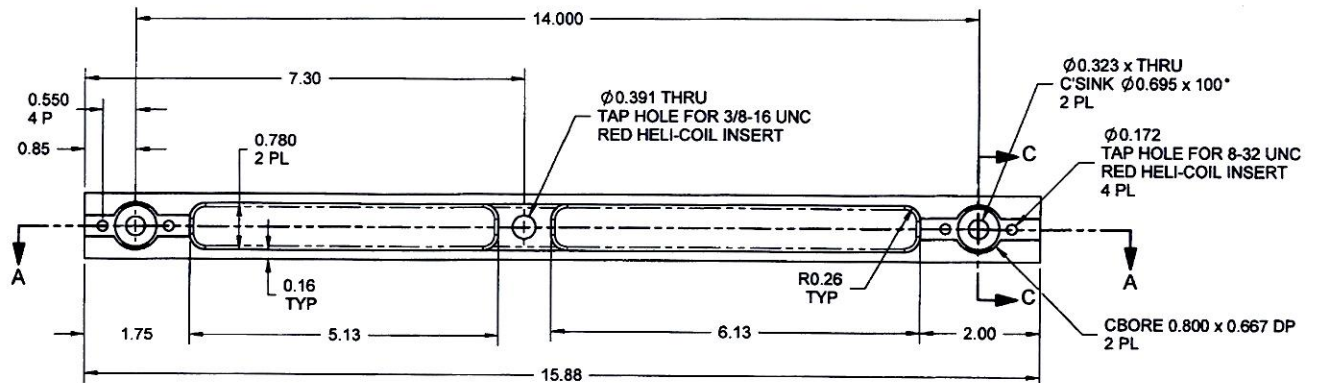
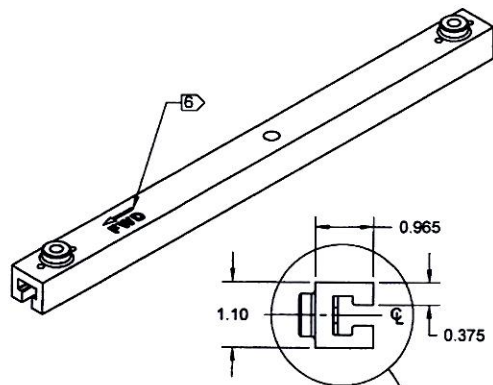
☒ **First Article**

 ☐ **Prototype**

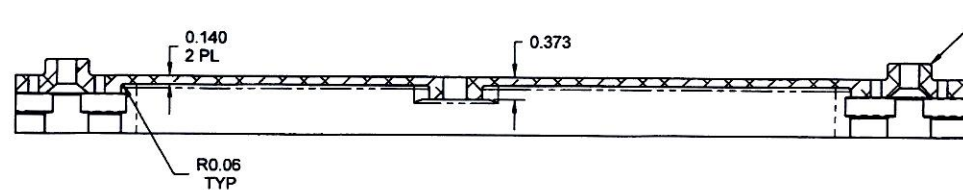
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.156	+/-0.010	.156	/		Vern	FK-04
Ø0.695	+0.008/-0.001	.695	/		"	"
Ø0.323	+0.006/-0.001	.323	/		"	"
Ø0.800	+0.010/-0.001	.800	/		"	"
R0.031	+/-0.010	.031	/		R-G.	

Measured by:	DAS 44 9-89	Audited by:	DAS 14 9-89	Prototype Approval:	N/A
Date:	17-01-11	Date:	17/01/13	Date:	N/A

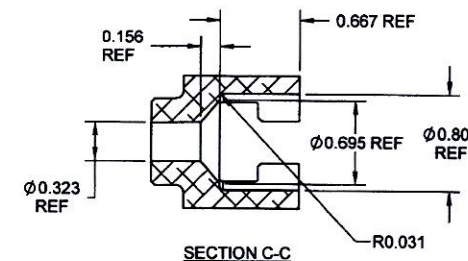
Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	



DETAIL VIEW B



SECTION A-A



SECTION C-C

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154967
ML5
19-01-04

D3808-1 SEAT RAIL

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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